



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9323	REV. A SHEET 1 OF 1
DATE 06.03.21		TITLE OVERSIZED INSERT REPLACEMENT SCALE NTS	
A	06.03.21	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. E OR REV. D

REF. CANADIAN STC: SH98-14 ISSUE 2

REF. FAA STC: SA00500SE

PURPOSE To allow replacement of inserts (rivnuts) in the D2841-041/-042 and D2842-041/-042 steps with larger inserts for situations where the insert holes are oversized because of damage.

PROCEDURE

It is acceptable to replace inserts in D2841-041/-042 or D2842-041/-042 steps as follows:

- 1) Open existing insert holes to Ø0.413" ('Z' drill). Deburr and touch up holes with MIL-P-85582 or MIL-P-23377 primer. Install **NAS1329C5KB125 or NAS1329C5K125 or NAS1329H5KB125 or NAS1329H5K125 inserts.**
- 2) Open corresponding holes in D2844-1, D2844-3, or D2845 arms to Ø0.323 ('P' drill).
- 3) Install step on aircraft per IIN-D206-628, however for all modified holes substitute the AN3C4A bolt and AN960C10 washer with **AN5C5A or AN5-5A bolt and AN960C516 or AN960JD516 washer.**
(ref: Figure 4 of IIN-D206-628 Rev.E, page 9)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 06.03.21
CERT. NO.: SH98-14
ISSUE NO.: 2

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